Owner's Manual

C93 SEMI-AUTO RIFLE

Cal. 5.56x45MM

Congratulations on your purchase of the C93 Rifle. With proper care and handling, it will give you long, reliable service. The C93 is a semi-automatic rifle chambered for the 5.56x45mm cartridge.

We specifically disclaim any responsibility for damage or injury whatsoever, occurring as a result of the use of faulty, non-standard or remanufactured ammunition, any modifications or changes made to the firearm; improper use or unsafe handling of the firearm.

FIREARMS SAFETY IS THE SOLE RESPONSIBILITY OF THE SHOOTER. ALWAYS TREAT ALL FIREARMS AS IF THEY WERE LOADED AT ALL TIMES!

IMPORTANT!

READ ALL INSTRUCTIONS AND WARNINGS IN THIS OWNER'S MANUAL AND ANY ACCOMPANYING LITERATURE BEFORE HANDLING, LOADING OR USING THIS FIREARM. If there is any aspect of the owner's manual or how to safely operate the firearm that you do not understand, contact Century International Arms, Inc., your firearms dealer or seek training from a professional qualified in the safe handling of firearms of this type BEFORE you handle, load or use this firearm.

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IMPORTANT SAFETY WARNINGS

These Safety Warnings are for your protection and the safety of others. Disregarding information in this Owner's Safety and Instruction Manual and accompanying literature may result in serious injury or death.

IMPORTANT SAFETY MESSAGE

Children are attracted to, and can operate firearms which can cause severe injuries or death. Prevent child access by always keeping guns locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison.

Firearm Safety Depends on You

A gun is only as safe as the person operating it. You can never be overly careful when handling a firearm. Carelessness is often the cause of shooting accidents, such as failing to keep the muzzle pointed in a safe direction, not being sure of your target and what is behind it, failing to engage the safety properly, leaving ammunition in the chamber or using improper loads. Since a bullet can never be called back once fired, such errors in gun handling can result in the loss of life, severe injury or property damage. It is thus crucial for your safety and the safety of those around you that you learn the principles of safe gun handling and storage before you begin to use your new firearm. Be a safe shooter - please read this instruction book thoroughly even if this is not your first firearm purchase as not all firearms are the same. The first step in being a safe shooter is to learn the rules for the safe operation and handling of firearms. There is nothing more important in gun handling than safety.

THE TEN COMMANDMENTS OF FIREARM SAFETY

The Ten Commandments of Firearm Safety must be etched into your memory before you begin to handle firearms. These rules are intended to be followed by all persons handling firearms in the field, on the range or at home. Please read, review and understand these rules before you begin to use or even take your new firearm out of its box. Remember, firearms safety depends on you! Memorizing these safety rules will help prevent gun accidents. Please study these safety rules before handling your firearm.

Commandment #1

Always Keep the Muzzle Pointed in a Safe Direction

This is the most basic and most important safety rule. A safe direction is one in which an accidental discharge will not cause injury to yourself, to others or property damage. This is particularly important when loading or unloading your firearm. Never point your gun at anything you do not intend to shoot. Treat every gun as if it were loaded at all times.

Commandment #2

Firearms Should Be Unloaded When Not Actually in Use

Firearms should only be loaded when you are in the field or on the target range or shooting area, ready to shoot.

When not in use, firearms and ammunition should be secured in a safe place, separate from each other. Remember to unload your firearm completely so that there is no ammunition in the chamber or magazine. Before handling this or any firearm, or handing it to someone else, visually check the chamber and magazine to ensure they do not contain ammunition. Always keep the guns action open when not in use. Never assume a gun is unloaded - even if you were the last person to use it. Never cross a fence, climb a tree, wade through a stream or perform any awkward movement with a loaded gun. When in doubt, unload your gun! Never pull or push a loaded firearm toward yourself or another person. Never carry a loaded gun in a scabbard, a holster not being worn or a gun case - common sense prevails in gun safety!

Commandment #3

Don't Completely Rely on Your Gun's Safety

Treat every gun as though it could fire at any time, even if you are not applying pressure to the trigger.

The "safety" on a firearm is a mechanical device which, like any such device, can become inoperable at the worst possible time and fail to function. By mistake, you may think the safety is "ON" when it actually is not. Or you may think your gun is unloaded when there is actually a round of ammunition in it. The safety serves as a supplement to proper gun handling but cannot serve as a substitute for common sense. Never handle a gun carelessly and assume that the gun won't fire just because "the safety is on." Never touch the firearm's trigger until you are ready to shoot. Keep your fingers away from the trigger when loading or unloading. Never pull the trigger when the safety is engaged or when the safety is positioned between the "SAFE" and "FIRE" positions. Never place your finger on the trigger unless you intend to fire.

Alcohol, Drugs and Guns don't mix. Make no mistake about it!

Never handle firearms after consuming alcohol or taking drugs that can affect your judgment. Shoot sober! Alcohol, certain kinds of drugs and firearms don't mix. Safe firearms handling requires alertness and concentration of one's actions. You cannot handle a firearm safely after consuming alcohol. Never consume anything that can impair your judgment or physical coordination when handling a firearm.

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Commandment #4

Be Sure of Your Target - And What Is Beyond It!

Once fired, a bullet (or shot charge) can never be called back, so before you shoot know where the bullet is going and what it will strike. Be certain your shot will not injure someone or strike something beyond the target. Never fire in the direction of noise, a movement or at any object you cannot positively identify. Be aware that a .22 Short bullet can travel over 1¼ miles. A centerfire cartridge, such as the .30-06, can send its bullet over 3 miles. Shotgun pellets can travel 500 yards and a shotgun slug has a range of over a half mile. Make sure your shot has a safe backstop such as a hillside. Keep in mind how far the bullet will travel if it misses your intended target. Once fired, a bullet can never be called back. You are responsible for your actions and judgment.

Commandment #5

Use the Correct Ammunition

Every firearm is designed to use a certain caliber or gauge of ammunition. It is important that you use the correct ammunition for your firearm. Information on the correct ammunition to use with your firearm appears in the firearm's instruction manual and the manufacturer's markings on the firearm itself. Use of the wrong ammunition, improperly reloaded ammunition or corroded ammunition can result in the destruction of the firearm, serious personal injury and/or death. Form the habit of examining every round of ammunition before you put it into your gun to ensure it is of the proper gauge or caliber and that it is in good condition.

Commandment #6

If Your Gun Fails to Fire When the Trigger Is Pulled, Handle With Care

If a cartridge or shell does not fire when the trigger is pulled, follow Commandment #1 and keep the firearm's muzzle pointed in a safe direction. Keep the muzzle pointed away from your face and anything you do not intend to shoot and wait at least 30 seconds (to ensure that the ammunition is not delayed in firing) before carefully opening the action, unloading the firearm and safely disposing of the ammunition.

Commandment #7

Always Wear Eye and Ear Protection When Shooting

Exposure to shooting noise can permanently damage hearing. Flying debris, such as powder residue and ejected cartridge cases can injure your eyes. Thus, it is only common sense to wear both eye protection (such as shooting glasses) and ear protection (such as a sound muffling headset) whenever shooting. Also, wear eye protection when cleaning or disassembling your gun to ensure that cleaning solvent and tensioned parts (such as springs), do not come into contact with your eyes.

Commandment #8

Be Sure the Barrel Is Clear of Obstructions Before Shooting

Discharging a firearm with an obstruction in the barrel can result in personal injury, property damage or death. Before you load your firearm, check the chamber and magazine to ascertain that no ammunition is inside. Also, check the inside of the barrel (called the "bore") to ensure it is free of obstructions. Even a small amount of mud, snow or excess lubricating oil or grease in the bore can cause excessive pressures resulting in a bulged or burst barrel which can injure or kill the shooter and bystanders. It's a good idea to make a habit of cleaning the bore and checking for obstructions with a cleaning rod just before each shooting session. If the noise or recoil experienced upon firing seems low or weak, or something doesn't feel "right," cease firing immediately and check to make sure that there is no obstruction in the barrel. Placing an undersized shell or cartridge into a gun (such as a 20 gauge shell in a shotgun chambered for 12 gauge ammunition) can result in the smaller round of ammunition falling into the barrel and acting as an obstruction. When a round is subsequently fired, the barrel may burst causing injury to the shooter and bystanders. For reference, re-read Commandment #5.

Commandment #9

Do Not Alter or Modify Your Gun and Have It Serviced Regularly

Firearms are complex mechanisms that are designed to function properly in their original condition. Any alterations or changes made to a firearm after its manufacture can make the gun unsafe and will void its warranty. Do not jeopardize your safety or the safety of others by altering the trigger, mechanical safety or other mechanisms of your firearm. You should have your firearm periodically checked for proper functioning and serviced by a qualified gunsmith.

Commandment #10

Learn the Mechanical and Handling Characteristics of Your Firearm

Not all firearms operate the same way. The method of carrying, handling and operating firearms varies with the mechanical characteristics of each gun. Thus, you should never handle any firearm until you become familiar with the safe handling, loading, unloading and carrying procedures for that particular firearm, as well as the rules for safe gun handling in general.

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LEAD WARNING!
Discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm and other serious injury. Have adequate ventilation at all times when shooting. Wash hands thoroughly after exposure.

Basics of Safe Gun Handling

1. Always keep the muzzle pointed in a safe direction.
2. Firearms should be unloaded when not actually in use.
3. Don't totally rely on your gun's safety.
4. Be sure of your target and what's beyond it.
5. Use the correct ammunition for your firearm.
6. If your gun fails to fire when the trigger is pulled, handle with care.
7. Always wear eye and ear protection when shooting and cleaning.
8. Be sure the barrel is clear of obstructions before shooting.
9. Don't alter or modify your firearm and have your firearm(s) serviced regularly.
10. Learn the mechanics and handling characteristics of the firearm you are using.

Safe gun handling depends on you! A safe shooter is a knowledgeable shooter.

SAFETY RULES AND PRECAUTIONS FOR FIRING AND USE OF THE C93

WARNING! Keep the C93's safety lever engaged in the "SAFE" ("S") position until you have aimed at a proper target and you have decided to fire. Failure to do so could cause serious injury or death.

WARNING! Use the C93's safety lever, but don't trust or rely on it as a substitute for safe gun handling practices. The safety is a mechanical device which could fail. Or, by mistake, you may think the safety is on when it is not. Or the safety may become disengaged without your knowledge. Or you could think your gun is unloaded when there is a cartridge in it. Always follow the safe gun handling rules and procedures in this manual, whether you think the safety is on or off, and whether you think the rifle is loaded or unloaded. Don't pull the trigger when the safety is engaged, or when it is positioned part way between "SAFE" ("S") and "FIRE" ("F"). Don't use or rely on the safety lever to try to "childproof" your rifle or keep it safe from untrained persons. Instead, your rifle should be unloaded and securely locked up, out of access of children and other unauthorized users.

WARNING! So that the rifle may be used as a single loader, it will fire whether or not a magazine is in the gun if a cartridge is in the chamber. Removing the magazine does not unload the rifle, and does not prevent the rifle from firing! A round left in the chamber after the magazine is removed can cause serious injury or death if the trigger is pulled! Unload your rifle properly, including checking the chamber both visually and physically.

WARNING! Keep your finger off the trigger and outside the trigger guard until you have aimed at a proper target and have decided to fire. Failure to do so could cause serious injury or death.

WARNING! When firing the C93, keep away (and keep others away) from the right side of the rifle. Fired cartridge cases eject (are thrown from the rifle) with considerable force from the ejection port on the right side of the rifle and could cause serious injury, including but not limited to eye injury, if they strike a person.

WARNING! Fired cartridge cases ejected from the C93 are extremely hot and can cause serious burns. In addition, the painful burn from a hot cartridge case can distract a shooter from keeping his firearm pointed safely and from other safe handling practices, causing a dangerous situation or an accident. When firing, stay clear, and keep others clear, of the right side of the rifle from which the hot cartridge cases are ejected.

WARNING! Keep hands, fingers and other body parts from touching the muzzle, barrel, ejection port area or chamber after firing as they could be burned by hot metal.

WARNING! If dropped or struck, whether the safety is "ON" or "OFF," the rifle may fire, causing serious injury or death. Keep the chamber empty unless actually firing! Keep the safety "ON" ("S") unless actually firing! When carrying or handling the rifle, keep it pointed in a safe direction, and carry it in such a way that you can safely control the direction in which the rifle points even if you should slip, stumble or fall. See other safety warnings regarding carrying or transporting the rifle in an unloaded condition, unloading the rifle before crossing obstacles or areas with poor footing, etc.

- Never transport or carry a loaded firearm in a vehicle or otherwise. Always transport or carry your rifle unloaded with the safety engaged ("S") and the action locked open. A suitable carrying case should be used to transport or carry your unloaded rifle to and from the range or other safe shooting area. Check the laws to determine and follow legal requirements in transporting a firearm in your jurisdiction. Close the rifle's action and load the rifle only when you are at the range or other safe shooting area, ready to begin shooting.

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- Never climb a fence, ladder, tree or other object, jump across a brook or ditch, crawl under a fence or other obstacle, walk across an icy surface, steep slope or other area with poor footing, or cross other slippery or precarious terrain or obstacles with a loaded firearm. Instead, unload your firearm first. When carrying your rifle in the field, keep the muzzle pointed in a safe direction and carry the rifle so you can safely control the direction in which it points in the event you stumble, slip or fall.

- Never shoot at a hard surface (rock, pavement, metal, ice, etc.) or at the surface of water, as the bullet may ricochet (glance off) the surface and travel in any direction, causing serious injury or death to someone you cannot see. Shoot only where there is a safe backstop (one which will safely stop and contain the fired bullets) free from rocks, hard objects and obstructions that could cause ricochets or splash-back of bullets, fragments, pebbles or rock particles. Check local and state laws to be sure shooting is permitted at the place you intend to shoot.

- When shooting, be alert to be sure no one comes into the line of fire. Check the backstop and target area carefully to be sure it is free of people each time before you begin to fire.

- When firing with a group of people, put a responsible person in charge to maintain safety, discipline and control to reduce the chance of accidents.

- On a firing range, be alert to the commands of the range officer and follow them precisely and immediately.

- Do not handle a firearm when anyone is forward of the firing position. Before anyone moves downrange to post or check targets or for any other purpose, all firearms should be unloaded, with safeties engaged and actions locked open, and placed safely on the bench where they should not be touched or handled until everyone returns from downrange.

- Do not handle firearms when you are tired, cold or impaired physically or mentally, in any way.

- Never fire your rifle near an animal unless it is trained to accept the noise of gunfire. An animal's startled reaction to the sound of gunfire could injure it or could cause an accident.

- Never continue to use your rifle if it is not functioning properly. Never force a jammed action as the jammed cartridge may explode if the primer is crushed or pressed against any metal part of the rifle or against another cartridge.

- Use only appropriate accessories for your C93 rifle. Be sure all accessories, including slings, ammunition carriers, sights and sight mounts, lighting devices, etc. are compatible with the firearm and do not interfere with its safe operation.

WARNING! Most ammunition and cartridge primers contain lead which is a toxic (poisonous) substance!
With most types of ammunition, shooting a firearm produces vapor and particles of lead which is a toxic (poisonous) substance. Especially (but not only) in poorly ventilated range areas, breathing air which contains the lead vapor and particles is harmful to one's health and can result in lead poisoning. Pregnant women, unborn fetuses, nursing mothers, infants and young children are especially susceptible to the risks of lead ingestion. Handling, firing and cleaning firearms, and handling ammunition, empty cartridge cases, target frames and other range equipment can deposit lead on one's hands and face, which can then be ingested (swallowed) if one drinks, eats or chews gum or tobacco products without first washing the hands and face. Lead poisoning can result in brain damage, nervous system disorders, digestive ailments, birth defects and other serious physical effects or death. Shoot only in well-ventilated areas. Minimize the period of time you remain on indoor shooting ranges, leaving when you are done firing. Do not eat, drink, chew, smoke or engage in any other hand-to-mouth activity while shooting. Wash the hands and face thoroughly with soap and cool water as soon as you are finished shooting, and before eating or drinking. Do not collect fired brass in your hat or put fired brass in your pockets. When you return from shooting, especially on an indoor range, change and wash your clothing. Do not allow children to handle or play with fired cases, shooting equipment, range bags or shooting clothing. Consider using rubber gloves when cleaning firearms to prevent lead and solvent from being absorbed into your skin. Wash thoroughly with soap and cool water after cleaning firearms. Take proper precautions if you reload ammunition or cast lead bullets. If you notice any symptoms or believe you may have been exposed to excessive amounts of lead, consult your physician.

Ammunition

The C93 rifle is chambered for the 5.56x45mm cartridge. You can also shoot the .223 Rem in this firearm. The ammunition box, and the head of each cartridge, should be marked with the designation ".223" or "5.56x45mm." The use of any cartridges other than these in the C93 rifle is unsafe and could cause damage to the rifle, serious personal injury or death.

Use only high quality, new, clean, dry, jacketed ammunition in excellent condition and in the proper caliber for the rifle. **Never use damaged, corroded or otherwise defective ammunition (ammunition which is dirty, wet, dented or deformed) or in which the bullet has been pushed back into the cartridge case or other ammunition of questionable quality, age or origin**. The use of reloaded, "remanufactured" or handloaded ammunition, unjacketed lead ammunition or any ammunition which is not manufactured to SAAMI (Sporting Arms and Ammunition Manufacturers Institute) or NATO standards will **void the warranty** and may be unsafe, possibly causing damage to the rifle, serious personal injury or death.

Keep ammunition dry, and free of oil, solvent, or grease. Firing ammunition with oil, solvent or grease on it can cause dangerously high pressure with possible damage to the firearm, serious injury or death. Oils and solvents can also penetrate ammunition, causing misfires.

General Description

The C93 semi-automatic rifle is a modern firearm produced in accordance with the most advanced manufacturing methods. It fires the 5.56x45mm cartridge. The C93 is a delayed blowback operated rifle with stationary barrel and delayed roller locked bolt system. The cartridges are fed from a 40 round magazine.

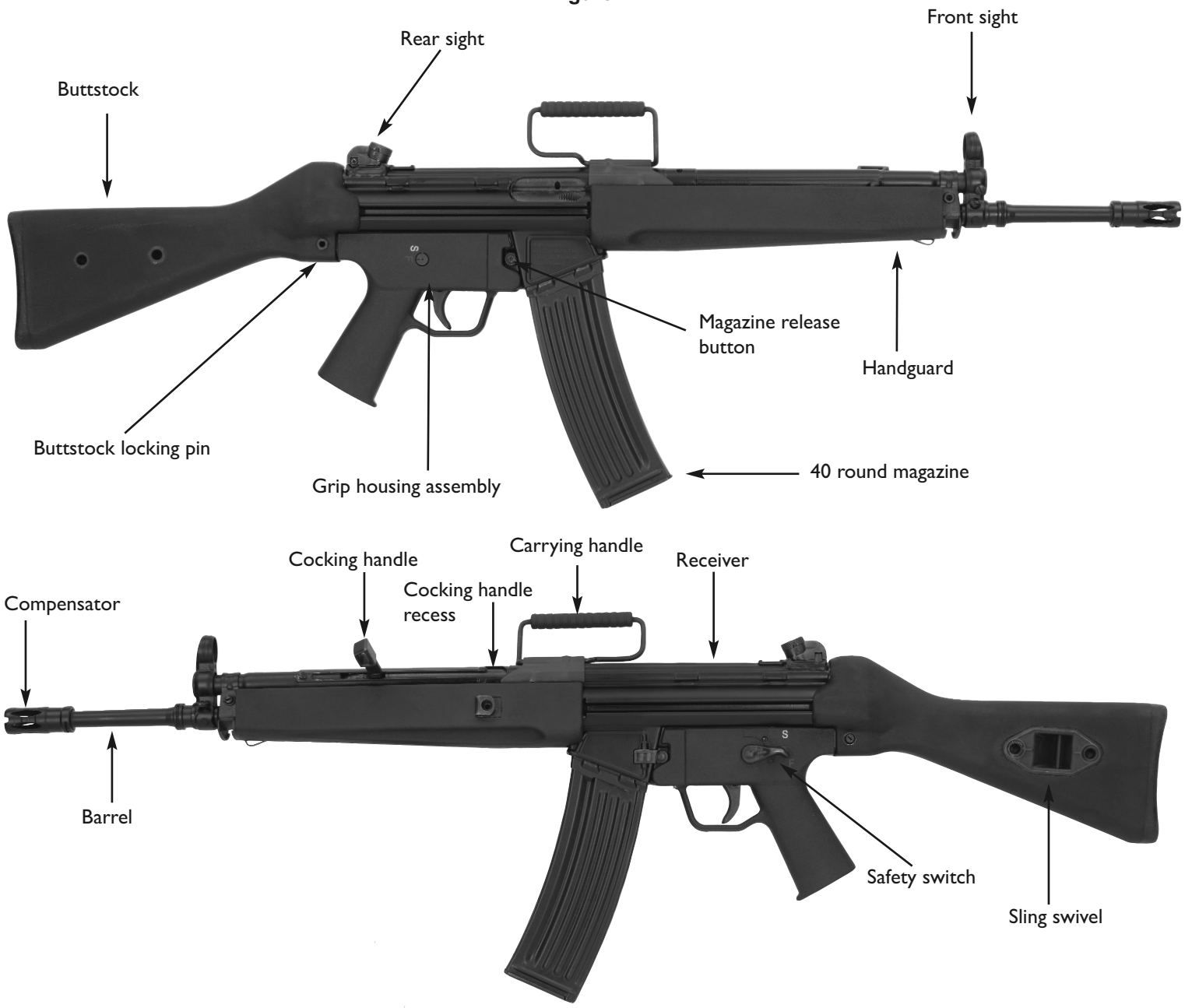
Technical Description

Caliber: 5.56x45mm. *Twist rate:* 1:9. *Front sight:* post, not adjustable. *Rear sight:* rotating diopter, adjustable, requires a tool. *Rear sight 4 positions:* an open V, plus settings for 200, 300 and 400 meters. *Sight radius:* 18.9." *Barrel length:* 16.25." *Overall length:* 36.5." *Weight without magazine:* 8.2 lbs.

Receiver

The receiver connects the barrel, cocking mechanism and sights and is the housing that mounts major assemblies. The barrel is press fit into the trunion and is fixed in place by means of a pin. The cocking mechanism is located above the barrel and serves for cocking, loading the firearm and to secure the bolt in its rear position. The sights consist of the front sight and rotary rear sight. The rotary rear sight has three aperture holes, small, medium and large, and one open "V" sight. The rotary rear sight can be adjusted for elevation and windage using a Phillips screwdriver and elevation adjusting tool. See Figure 25.

Figure 1



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Bolt Assembly

Figure 2

Recoil spring guide rod with recoil spring

Bolt head with locking rollers and extractor

Bolt locking piece

Firing pin spring

Firing pin

Bolt head carrier with recoil spring tube

Grip Assembly

The grip assembly is hung from the receiver and can be removed from it. It houses the trigger assembly with hammer, ejector and the safety. The safety lever axle connects the grip frame to the trigger assembly.

Figure 3

Grip Assembly
- Grip frame
- Trigger assembly
- Safety lever

Figure 4

Axle safety lever

Trigger assembly and safety lever

Buttstock

The fixed buttstock closes the rear of the receiver. It is connected to the receiver by a locking pin. The sling loop is part of the buttstock. One of the tubular rivets serves to store the buttstock locking pin when stripping the firearm.

Locking pin

Figure 5

Handguard

The detachable handguard encircles the barrel from below. It is fastened to the firearm by a locking pin.

Locking pin

Figure 6

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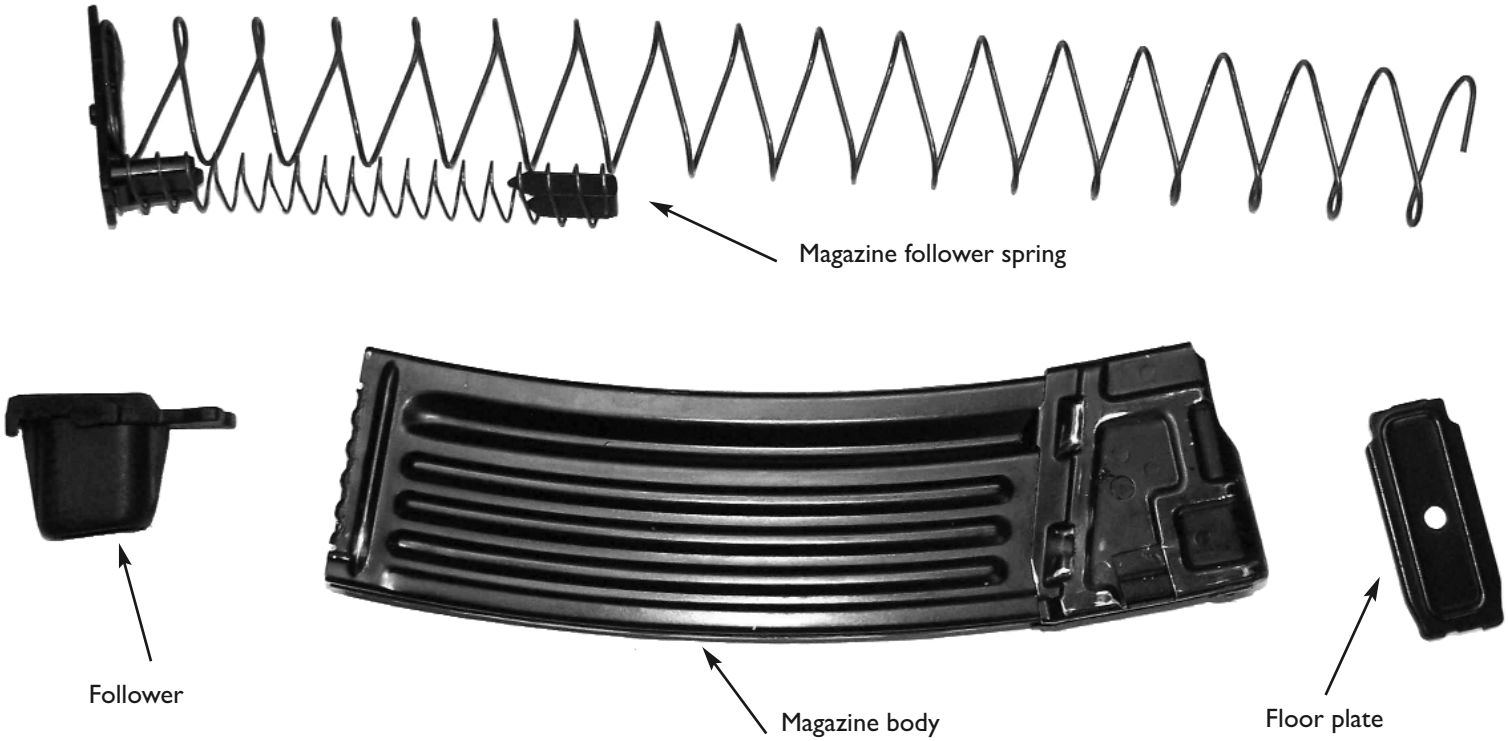
Magazine

The cartridges are fed from a 40 round magazine. The magazine consists of:

- Magazine housing with magazine floor plate.
- Follower with follower spring and locking plate.

Figure 7



Handling and Operation

Safety Lever

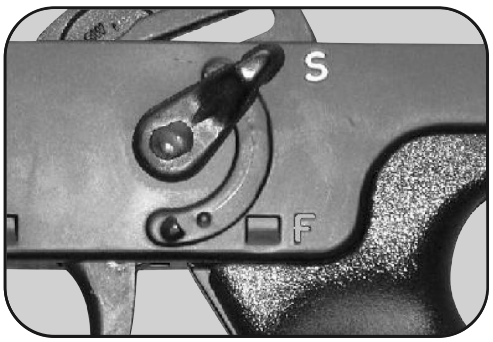
The safety lever is located on the left side of the grip assembly and can be set at the white "S" for "SAFE" or a red "F" for "FIRE." The position selected is also indicated on the right side of the grip assembly where an indicator line on the safety axle (round pin) points to a white "S" for "SAFE" or a red "F" for "FIRE" depending on the model of C93. See Figure 8 and Figure 9.

Safe Position

Safe: Set safety lever at the white "S." See Figure 8. The trigger cannot be squeezed. However, the firearm can be loaded or unloaded while in the "SAFE" position.

Figure 8 "SAFE" Position

Lever on left side of grip



Standard Model

Indicator on right side of grip

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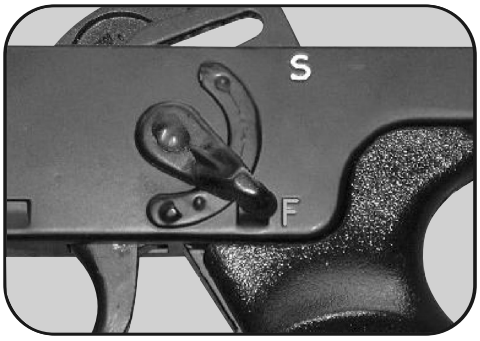
Fire Position

Fire: Set the safety lever at the red "F." See Figure 9. The trigger can be pulled, allowing the rifle to fire.

Figure 9 "FIRE" Position

Lever on left side of grip



Standard Model

Indicator on right side of grip

WARNING! The safety lever should be kept engaged in the "SAFE" ("S") position at all times until the rifle is aimed at a proper target and you intend to fire. The rifle will FIRE if the safety lever is not completely on the "SAFE" ("S").

WARNING! The safety lever is a mechanical device that, under some circumstances, can fail to operate properly to keep the firearm from firing. Use the safety lever but never rely upon it as a substitute for safe firearm handling practices. Follow the safety rules in this manual at all times

"Clearing" (or unloading) the Firearm

"Clearing" the C93 rifle means unloading it and checking to positively verify that it is unloaded and clear of any ammunition with the safety lever engaged and the bolt locked to the rear. Thus, the same procedure is used for "Clearing" the rifle as for "Unloading" it. Except when actually being fired or about to be fired at a safe range or other shooting area, the C93 rifle should be cleared whenever it is handled, inspected, transported, stored, taken from storage, handed from one person to another, prepared for being stripped or cleaned.

To "Clear" (or Unload) the C93, proceed as follows:

WARNING! While "Clearing" the rifle, follow all safety rules in this manual. Keep the muzzle pointed in a safe direction and keep your fingers off the trigger and outside the trigger guard! Failure to do so may result in serious injury or death, due to an accidental discharge of the firearm!

1. Engage the safety lever by placing it in the "SAFE" ("S") position. See Figure 8.

2. Remove the magazine by pressing the magazine catch and pulling the magazine out of the magazine well.

3. Grasp the cocking lever and pull it all the way to the rear, engaging it in the recess in the cocking lever housing, to extract and eject any cartridge that may be in the chamber.

WARNING! Do not rely on the extractor of this, or any other, firearm to positively extract any cartridge that may be in the chamber. A worn, faulty or dirty extractor, dirty bolt face, dirty chamber, undersized or defective cartridge may result in the cartridge remaining in the chamber even after the bolt has been pulled to the rear. ***ALWAYS confirm that the chamber is empty and free of all ammunition by checking it visually and physically (with a fingertip), as described below! Failure to do so can result in serious injury or death if a cartridge remains in the chamber.***

4. **Disengage the cocking lever from the recess and allow it to snap forward.** Do not "ride" the cocking lever forward by continuing to hold it, slowing its forward movement, as this can prevent the bolt from closing properly and prevent the extractor from engaging a cartridge which has remained in the chamber.

5. **Grasp the cocking lever and pull it all the way to the rear a second time, engaging it again in the recess in the cocking lever housing.** Retracting the bolt a second time in this way is safer than retracting the bolt only once as it may serve to extract and eject any cartridge which has remained in the chamber the first time (see Step 3 above, including "WARNING!") and can also alert the user that he/she has failed to first remove the magazine, when a second cartridge ejects from the rifle!

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6. **VISUALLY check the chamber to confirm that no cartridge or cartridge case remains in the chamber, and that the chamber is completely empty. NEVER** rely on the extractor to positively extract any cartridge which may be in the chamber - **ALWAYS** check the chamber visually after retracting the bolt. In poor light, you may need to use a flashlight or other light source to check the chamber properly. Also check the magazine well visually, to confirm that the magazine has been removed. Failure to perform the visual check could result in serious injury or death, if a cartridge is left in the rifle by mistake!

7. **PHYSICALLY check the chamber and the magazine well by inserting your finger through the bottom of the magazine well and upward into the chamber to be sure no magazine remains in the rifle and there is no cartridge or cartridge case in the chamber.** This "double check" (physical as well as visual) is important to confirm that the rifle is truly unloaded and that a cartridge has not been overlooked due to poor light, haste or inattention. Failure to perform the physical check could result in serious injury or death if a cartridge is left in the rifle by mistake!

8. **Leave the safety lever on "SAFE" ("S"), the magazine removed and the action locked open with the cocking lever locked in the recess of the cocking lever housing.** The C93 rifle is now "Cleared." Despite the fact that it has been "Cleared," continue to follow all safety rules in this manual including treating it as you would treat a loaded firearm, and pointing it in a safe direction at all times.

WARNING! Follow the above "Clearing" (unloading) procedures exactly and carefully! Failure to do so can result in serious injury or death if a cartridge is left in the rifle.

Filling the Magazine

Filling the Magazine

Hold the magazine in one hand. With the other hand, put a cartridge in the magazine opening with the tip of the bullet pointing forward, toward the front (more open end) of the opening. Press the cartridge straight down under the magazine lip with your thumb. See Figure 10. Repeat with additional cartridges. Do not overfill the magazine or damage to the magazine may result.

Figure 10 Filling the magazine

Emptying the Magazine

Grasp the magazine in one hand, with the bullet end of the cartridge pointing toward your other hand. Use either thumb to push the cartridges into your open hand. See Figure 11.

Figure 11 Emptying the magazine

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Loading the Firearm

WARNING! Follow all safety rules in this manual while loading the rifle, including keeping it **pointed in a safe direction and keeping your fingers off the trigger and outside the trigger guard.** Failure to do so may result in serious injury or death in the event that the gun discharges.

WARNING! The C93, like many other firearms could possibly discharge when the bolt closes, even without the trigger being pulled! This could occur due to defective ammunition (high primer, etc.) debris on the bolt face, mechanical malfunction or other causes. To avoid serious injury or death, load **ONLY** while pointing the rifle in a safe direction.

To Load the Rifle

Grasp the magazine in one hand, with the bullet end of the cartridge pointing toward your other hand. See Figure 12.

1. Put the safety lever into the "SAFE" ("S") position! See Figure 8.

2. Pull the cocking lever rearward, engaging it in the recess in the cocking lever housing.

3. Insert the filled magazine into the magazine well with the bullet end of the cartridges pointing forward so that the magazine catch locks the magazine audibly into position. ***(Note: You may need to rock the magazine slightly from front to back to get it to lock in place.)*** Pull downward on the magazine to ensure it is locked in place.

Figure 12 Inserting the magazine

You may need to rock the magazine to lock in place.

Figure 13

Pull downward on the magazine to ensure it is locked in place.

4. Allow the cocking lever to snap forward. Do not "ride" the cocking lever forward (that is, DO NOT hold onto the cocking lever as it moves forward.) "Riding" the cocking lever can cause malfunctions in feeding, chambering, locking and firing.

The firearm is now loaded in the "SAFE" ("S") position. When the safety lever is disengaged (switched to "FIRE" ("F") position) and the trigger is pulled, the rifle will fire!

Figure 14 Retracting the cocking lever

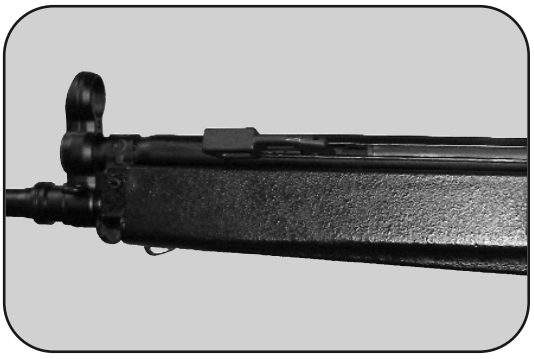
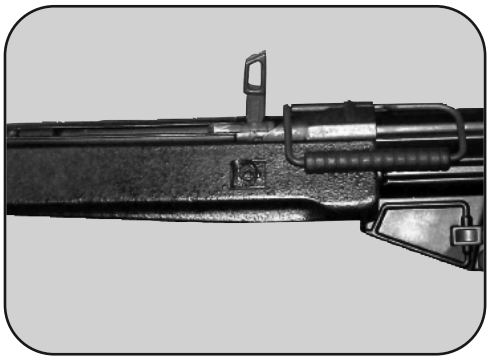


Figure 15 Releasing the cocking lever



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Unloading

To unload the rifle, follow the procedure set out in "Clearing" (or Unloading) the firearm.

Firing the Rifle

WARNING! Follow all safety rules and procedures in this manual. Among other things, **use proper eye and ear protection, keep the rifle pointed in a safe direction at all times, keep the safety lever engaged and your finger off the trigger and outside the trigger guard until the rifle is aimed at a proper target and you intend to fire.** Failure to strictly follow these and the other safety rules in this manual and any accompanying literature can result in serious injury or death.

To fire the rifle, proceed as follows:

1. "Clear" the rifle.

2. Fill a magazine with proper ammunition.

3. Load the rifle.

4. Before firing, check again to be sure that the target and backstop area are safe and free of any people or animals which could be injured by your shot(s), that you and everyone around you are wearing proper eye and ear protection and that no one is standing to the right of the rifle where they might be struck and injured by the ejected cases.

5. Hold the rifle as shown in Figure 16 with the butt of the rifle firmly seated on your shoulder, your strong (dominant) hand grasping the grip of the rifle (with trigger finger ***outside the trigger guard*** **until you have aimed and you intend to fire)**, your weak (non-dominant) hand grasping the handguard of the rifle, and your cheek against the stock of the rifle positioned so you can aim using the sights. **Be careful that no part of your body is near or in front of the muzzle, or in the way of the ejection port from which hot, fired cartridge cases will eject with considerable force when you fire the rifle!**

Figure 16

6. Aim the rifle at the target.

7. Disengage the safety lever by moving it from "SAFE" ("S") to "FIRE" ("F").

8. Place your finger on the trigger and while keeping the sights aligned on the target, move the trigger smoothly rearward until the rifle fires. The key to accurate shooting is moving the trigger in such a way as not to disturb the alignment of the sights on the target until the rifle fires.

WARNING! The C93 is a semi-automatic rifle. When you fire it, it will automatically extract and eject the fired cartridge case and feed a live round of ammunition from the magazine into the chamber. Thus, after firing a shot, it will instantly be ready to fire again if the trigger is pulled. Be careful!

9. Repeat step 8 until you have fired the desired number of shots.

10. If a malfunction ("stoppage") occurs while firing, follow the procedure explained below.

11. Immediately when you are finished firing, engage the safety lever by moving it to the "SAFE" ("S") position and **UNLOAD the rifle.** While unloading the rifle and after it is unloaded, continue to follow all of the safety rules contained in this manual including **keeping it pointed in a safe direction and keeping your finger off the trigger and outside the trigger guard** at all times.

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WARNING! Unlike some other firearms, the C93 bolt does not lock open automatically when the rifle is empty (that is, it does not lock open on an empty magazine). Thus, when firing, a C93 with the bolt closed may or may not have a cartridge in the chamber. The only way to positively confirm that the chamber is empty is to check it visually and physically following the "Clearing/Unloading" procedure starting on page 9.

Malfunctions

Any firearm will, on occasion, malfunction. Malfunctions (or "stoppages") can include the rifle failing to fire (with or without going "click") when you pull the trigger; failing to extract or eject the fired cartridge case upon firing; "stovepiping" or trapping the fired case in the ejection port, failing to feed a round from the magazine or chamber the round as the bolt moves forward; "double feeding" or feeding two rounds from the magazine at one time; failure of the bolt to close fully, preventing the rifle from firing; or a "squib" (underpowered) cartridge which does not develop sufficient power to cycle the action **and may leave a bullet lodged in the barrel.**

If you experience a malfunction, **keep the muzzle pointed in a safe direction.**

Engage the safety lever by putting it on "SAFE" ("S"). Continue to hold the rifle aimed at the target and backstop for 30 seconds in case you have a "hangfire" (slow or delayed ignition of the cartridge). If the round does not fire within 30 seconds, **keeping your face (and everyone else's) away from the ejection port, your fingers off the trigger and outside the trigger guard, and the rifle pointed in a safe direction,** then proceed as follows:

1. Remove the magazine.

2. Pull the cocking lever rearward to eject the chambered round, locking the cocking lever into the recess in the cocking lever housing.

3. Inspect the chamber and breech area to be sure there are no cartridges or portions of cartridges remaining there. Then field strip the rifle (See Page 15) and look through the bore from the rear to be sure it is not obstructed.

4. Segregate the faulty or damaged round of ammunition for proper disposal in accordance with the ammunition manufacturer's instructions.

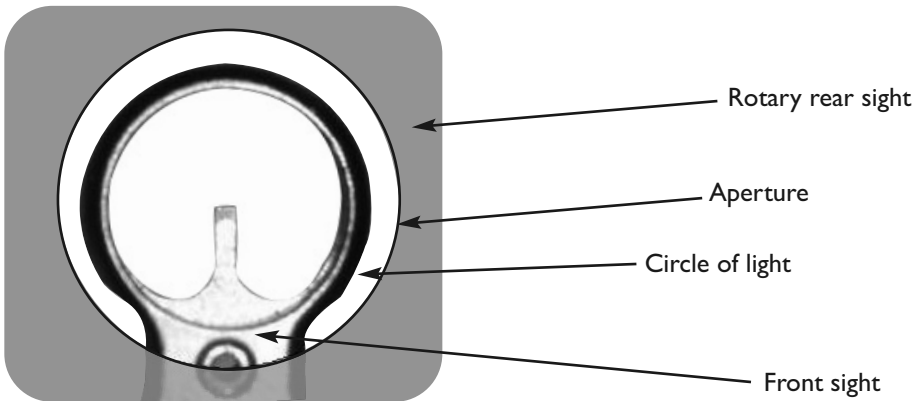
5. If the rifle is free of ammunition, fired cases, other debris or bore obstructions, you may reassemble it, reload it and continue firing.

WARNING! If you experience a weak report (weak gunshot sound) or unusually light recoil upon firing, you may have fired a "squib" (underpowered) cartridge which may have left a bullet lodged in the barrel. **STOP FIRING IMMEDIATELY.** Engage the safety lever by moving it to "SAFE" ("S"). "Clear" (unload) the rifle, leaving the safety lever on "SAFE," the magazine removed, the rifle unloaded and the cocking lever engaged in the recess in the cocking lever housing. Then field strip the rifle and look through the bore from the rear to be sure it is unobstructed. If the bore is unobstructed, you may reassemble and load the rifle and continue firing. If there is an obstruction in the bore, the rifle should be taken to a qualified gunsmith or certified armorer, or returned to the factory to have the obstruction removed and the barrel inspected for damage before continuing to use the rifle. **NEVER attempt to "shoot out" an obstruction by firing another cartridge, even a cartridge from which the bullet has been removed, in the rifle. Damage to the rifle, serious injury or death could result**!

Aiming

Before aiming, rotate the rear sight to the desired position (small, medium, large aperture or open "V" sight) and select the aiming point (target). Now aim at the target by means of the aperture hole and the front sight. Make sure that the target appears to be resting on top of the front sight post and is properly centered and that there is an even circle of light between the inner circumference of the aperture hole and the outer circumference of the front sight holder.

Figure 17 In this sight picture, the front sight is centered precisely in the aperture hole providing the correct point of aim!



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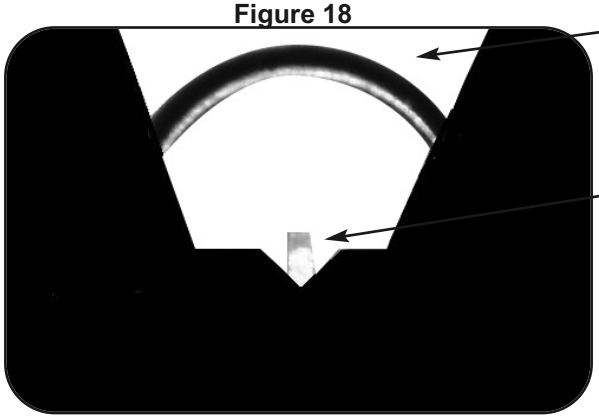
Open "V" Rear Sight. This rear sight option may be preferred by some users for very close-range, fast shooting, dim light conditions and other situations where use of the aperture rear sights might be difficult. Sight alignment using the Open "V" should look like this:

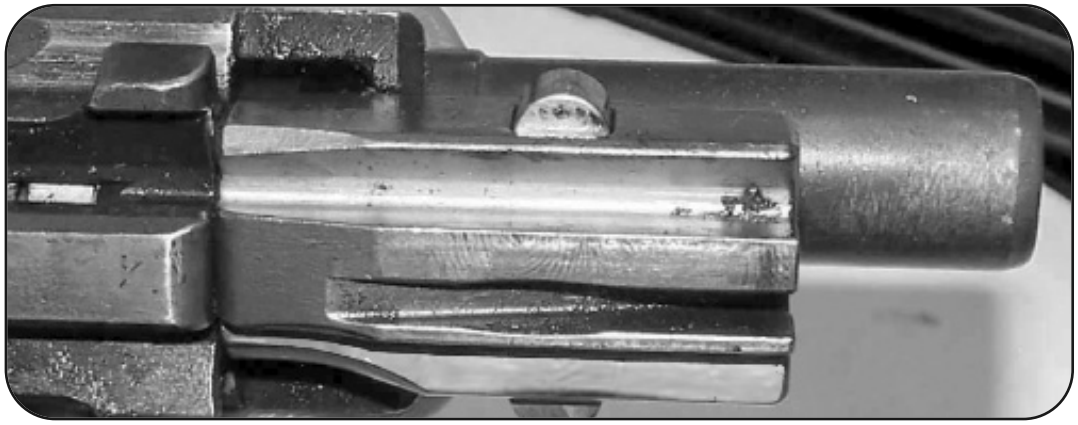
Figure 18


Front sight ring
Rotary rear sight
Front sight post and point of impact
The front sight post is even with the top of the "V" and centered in the "V" to provide the correct point of aim.

How the Firearm Functions

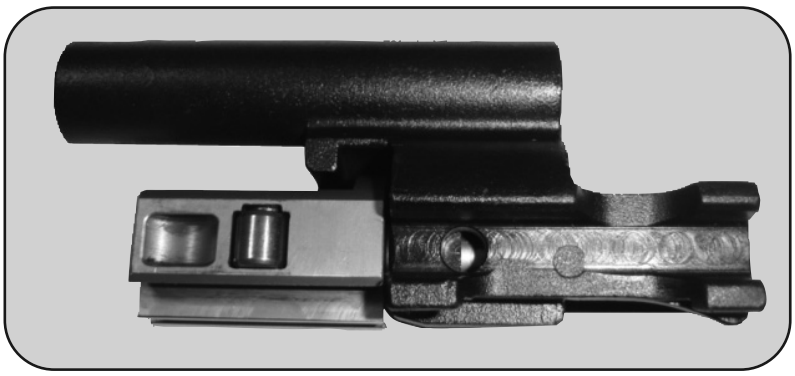
When the firearm is loaded and the safety is set to "F" or "FIRE" position and by pulling the trigger, the hammer is released and strikes the firing pin which in turn ignites the cartridge. The powder is burned and produces gas which drives the bullet out of the barrel. Simultaneously, the gas exerts pressure on the cartridge case. This causes force to act on the bolt head face; a portion of the force is transmitted to the receiver and a portion to the bolt carrier via the locking piece. The balanced angular ratio of the locking piece and barrel extension result in a delayed blowback movement of the bolt head. This delay guarantees that the bolt stays locked until the bullet has left the muzzle.

Figure 19 Bolt in the locked position



After the locking rollers have been fully cammed into the bolt head, the bolt can continue its movement to the rear. In the course of the movement, the empty cartridge case is extracted and ejected and the hammer is re-cocked. Simultaneously, the recoil spring is compressed. The compressed spring now pushes the bolt forward, returning the bolt to its forward position. During the course of this action, a new round is fed from the magazine and chambered. The extractor engages the extracting groove in the cartridge case. As a result of the beveled surfaces of the locking piece, the locking rollers are cammed against the supporting surfaces in the barrel extension. The firearm is now ready to fire again.

Figure 20 Bolt in unlocked position



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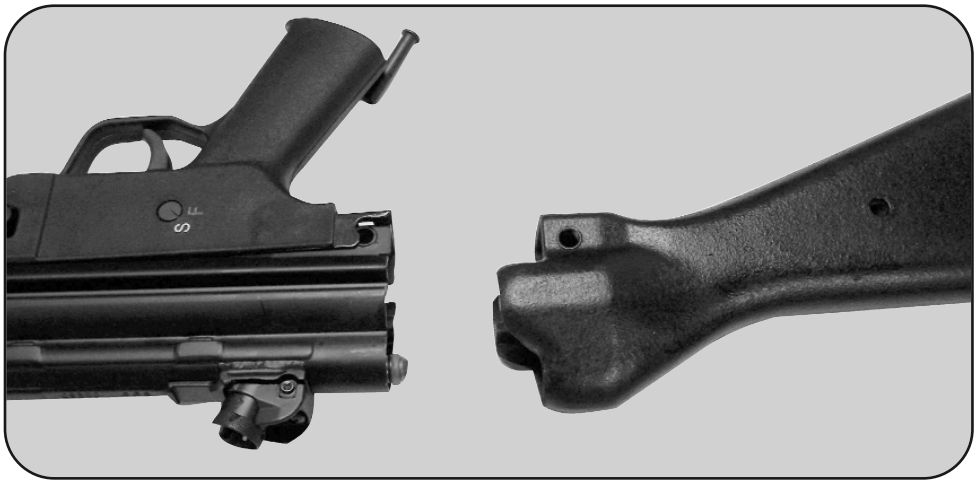
WARNING! The C93 is a semi-automatic rifle. When you fire it, it will automatically extract and eject the fired cartridge case and feed a live round of ammunition from the magazine into the chamber. Thus, after firing a shot it will instantly be ready to fire again if the trigger is pulled. Be careful!

Figure 21 Remove the buttstock



Field Stripping and Cleaning

Put the safety lever on "SAFE" by pushing the safety lever to the "SAFE" ("S") position!

1. "Clear" (unload) the rifle and confirm it is unloaded visually and physically by following the steps of the "Clearing" (unloading) procedure.
2. If you have installed a carrying sling, unhook it from the front sight holder.
3. Remove the buttstock locking pin and store it in the tubular rivets in the fixed butt stock.
4. Slide off the buttstock. See Figure 21.
5. Remove grip assembly.
6. Retract bolt assembly by means of moving the cocking lever rearward and remove it from the receiver.
7. Remove handguard, storing the locking pin in the hole in the handguard.

Stripping the bolt assembly

1. Remove the bolt head from the bolt assembly by turning it 90 degrees clockwise. See Figure 22.
2. Turn the locking piece until the lug is clear and can be withdrawn from the bolt head carrier. See Figure 23.
3. Remove firing pin with its spring. See Figure 2 on page 7.
4. Clean the bolt assembly parts with solvent, brushing with a nylon or bronze brush if necessary. Dry and lightly lubricate the parts before re-assembly.

Figure 22 Remove the bolt assembly components

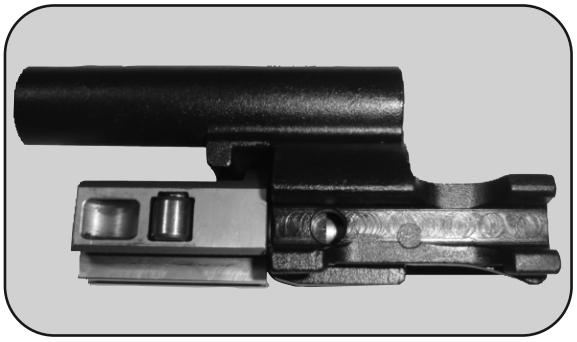
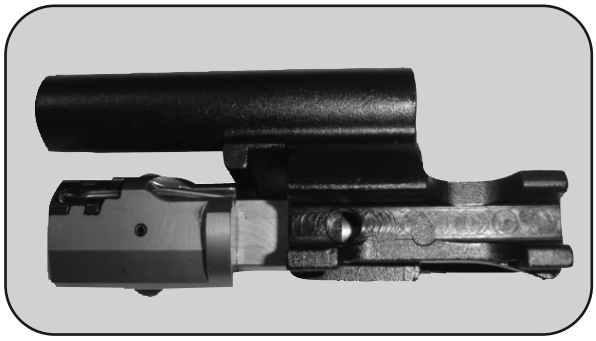


Figure 23 Remove the bolt assembly



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Re-assembling of the bolt is done by reversing the disassembly procedure. Push the bolt head with its slanted surface under the nose of the locking lever, holding a distance of about 5 mm to the bolt head carrier, and turn counter-clockwise until the slide-surface of the bolt head and the bolt head carrier are at the same level.

Stripping the grip assembly with trigger mechanism

Set the safety lever to point vertically upwards, then pull the safety lever out. Remove the trigger assembly from the grip frame. Only trained and certified armorers or gunsmiths should carry out further disassembly. If the grip assembly/trigger assembly is extremely fouled, it should be washed out, using an aerosol cleaning solvent, then dried and lightly lubricated.

Cleaning the Bore

Working from the chamber end, clean the chamber and bore using a bronze brush, patches, solvent and cleaning rod until a patch comes out clean. Clean the chamber face (flat shoulder at the rear of the chamber) with a bronze brush. Dry the bore with clean dry patches and lubricate lightly with gun oil.

WARNING! Firing the rifle with grease, excess oil or other obstructions in the barrel can produce excessive pressure, resulting in damage to the rifle and serious injury or death. Leave only a thin film of gun oil in the bore and remove excess oil using a clean dry patch on a cleaning rod before firing.

WARNING! Keep oil and solvent out of contact with ammunition as oil and solvent can penetrate cartridges and cause misfires. Oil or solvent on ammunition can also cause dangerously excessive pressures when the rifle is fired. The bore, chamber, bolt and inside of the magazine should be dried of excess solvent and oil to prevent contact with ammunition.

Re-assembling the Firearm

1. Attach handguard and insert locking pin.

2. Insert the assembled bolt with recoil spring into the receiver (locking rollers must rest inside the bolt head).

3. Attach grip assembly.

Figure 24

4. Engage the safety lever on the grip by moving it to "SAFE" ("S").

5. Slide the fixed buttstock onto the receiver and insert the locking pin.

6. Check the proper re-assembly of the firearm by confirming that it is empty (unloaded) as explained in ("Clearing" the Firearm), pointing it in a safe direction, performing several cocking motions, dry firing the firearm (that is, pulling the trigger to release the hammer with **NO AMMUNITION IN THE FIREARM)** and pulling the trigger with the safety lever on "SAFE" ("S") to confirm that the trigger will not pull and the hammer will not fall with the safety lever engaged.

Adjusting the Sights

WARNING! Only adjust the sight when the firearm is unloaded, safety lever is on "SAFE" ("S") and the bolt is locked open by engaging the cocking lever in the recess of the cocking lever housing.

Any corrections that may be required can only be performed by adjusting the rear sight for elevation and windage. To adjust windage, you will need a proper-sized Phillips screwdriver. To adjust elevation, you will need the elevation adjusting tool available from a retail dealer or other sources, plus a Phillips screwdriver that fits properly in the elevation adjustment tool.

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Elevation Adjustment

1. Insert elevation adjustment tool into the rear sight cylinder so that the wedges of the tool engage in the two splines in the cylinder which contains the catch bolts. Press a Phillips screwdriver downward into the adjusting tool and hold fast. Turn the rear sight cylinder in the desired direction. See Figure 25.

2. To lower the point of impact, turn clockwise. To raise the point of impact, turn counter-clockwise. Each one-quarter (¼) turn moves the point of impact approximately 0.55 inch (1.4 cm) at 25 meters (27 yards), or 2.2 inches (5.6 cm) at 100 meters.

3. After correction, remove screwdriver and elevation adjustment tool. The catch bolts will re-engage in the splines.

4. After performing the elevation adjustment, set rear sight cylinder at the desired sight position: small, medium, large aperture or open "V" sight.

NOTE: Rotating the sight does not change the elevation setting unless the elevation adjustment tool is used. Rotating the sight only allows the user to select the size of the aperture or "V" opening desired.

Figure 25 Elevation adjustment

Windage Adjustment

Point of impact left: Loosen clamping screw on top of sight base. See Figure 26. Turn adjusting screw counter-clockwise as required. See Figure 27. Retighten clamping screw.

Point of impact right: Loosen clamping screw on top of sight base. Turn adjusting screw clockwise as required. Retighten clamping screw.

NOTE: Each revolution of the adjusting screw moves the mean point of impact approximately 2.16 inches (5.5cm) to either side at a range of 25 meters (27 yards), 8.64 inches (21.9 cm) at 100 meters (109 yards).

Figure 26

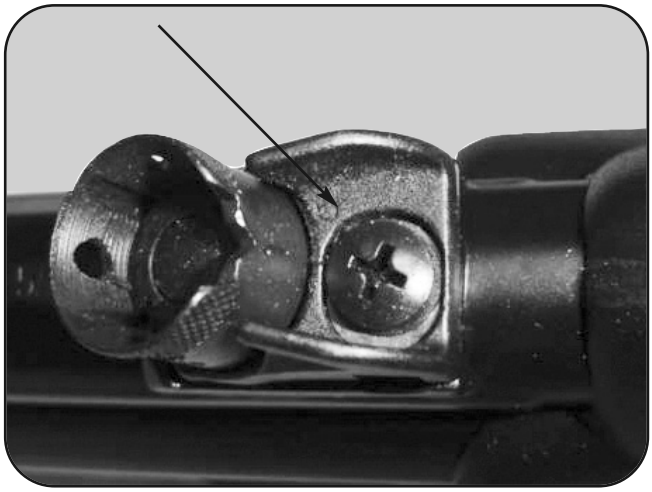
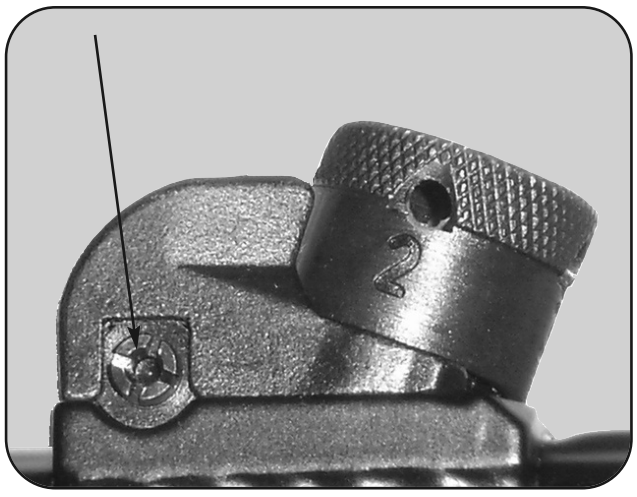


Figure 27



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Cleaning Intervals

Always clean your rifle as soon as possible after firing to prevent buildup of shooting residue and to prevent corrosion from starting.

To maintain your rifle in good working order, it should be cleaned once or twice a year in low-humidity environments, even if it has not been fired. In a high humidity area, it may be necessary to clean your rifle as often as once a week.

Note: In freezing weather (below 32 degrees F. or 0 degrees C.) the use of a dry lubricant (instead of oil) for lubrication may work better.

To Clean the Barrel

1. Obtain a quality rifle cleaning kit and thoroughly review its instructions provided.

2. Lock the rifle's bolt in the open position by pulling the operating handle fully to the rear.

3. To clean the barrel, select the correct caliber cleaning brush and attach it to a cleaning rod.

4. Dampen the brush with gun cleaning solvent and then push the brush through the barrel several times.

5. Remove the brush and attach a correctly-sized cloth cleaning patch to the cleaning rod and push it through the barrel several times to remove loosened fouling.

6. Repeat this process with the brush and cleaning patches until a final patch comes out clean after swabbing the bore.

7. Repeat the procedure just followed to clean the bolt and other action parts.

8. Remove shooting residue from the rifle's outside by wiping surfaces with a soft cloth dabbed in solvent. Dry surfaces.

9. Finally, wipe down all outside surfaces with a soft cloth dipped in a good quality metal preservative oil.

WARNING! There may be sharp edges on parts of the firearm. Keep fingers protected by wearing a pair of protective gloves when cleaning.

WARNING! Excessive use of cleaning solvents or lubricants can adversely affect your rifle's functioning. Wipe dry the inside of the barrel before firing and ensure it is free of obstructions.

WARNING! This firearm should be checked periodically for worn or damaged parts by a competent gunsmith. This will help ensure its safe functioning and a long service life.

WARNING! Some cleaning solvents produce hazardous vapors. Read and follow the solvent manufacturer's cautions found on the product's package.

WARNING! Handling ammunition and cleaning firearms results in exposure to lead and other substances that can pose health risks. Wash your hands and face after firing your rifle or after cleaning it.

Storage

When putting your rifle away for storage, it should be thoroughly cleaned and lightly lubricated. Outside surfaces should be wiped with a light coat of good quality gun oil. CHECK TO ENSURE YOUR FIREARM IS UNLOADED BEFORE PUTTING IT AWAY FOR STORAGE BY VISUALLY EXAMINING BOTH ITS CHAMBER AND MAGAZINE. Store the rifle in a separate location from its ammunition. When the rifle is to be reused, remove all excess lubrication before firing. Make certain that the bore (inside of barrel) is dry and free of obstructions before firing.

NOTE: The use of reloaded, re-manufactured, hand-loaded, or other non-standard ammunition may result in damage to the rifle and injury or death to the shooter and/or bystanders. The manufacturer and importer cannot accept responsibility for malfunctions resulting from the use of non-standard, defective ammunition.

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C93 Semi-Auto Rifle, Cal. 5.56x45mm

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